

Date: Tuesday, 21/04/2009 4:01:21 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BUSHING
 Job Number : 47351
 Estimate Number : 13679
 P.O. Number :
 This Issue : 21/04/2009 S.O. No. :
 Prsht Rev. : NC Part Number : D38641
 Drawing Number : D3864 REV A
 Project Number : N/A
 First Issue : / / Type : MACHINED PARTS Drawing Revision : A
 Previous Run : 46598 Material :
 Due Date : 27/04/2009 Qty: 40 Um: Each
 Written By :
 Checked & Approved By : JD 09.04.21
 Comment : Est Rev:A New Issue JLM 08-12-06 Verified By:EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M303R1000 303 Round Bar 1.00



4.23 ft



Comment: Qty.: 0.1061 f(s)/Unit Total: 4.2420 f(s)
 303 Round Bar 1.0"
 Batch: M110379

SA 09/04/25

2.0 HARDINGE HARDINGE CNC LATHE SMALL



Comment: 1-TURN AS PER FOLIO FA794 & DWG D3864 ,
 FOLIO REV: 4
 DWG REV: 4

2-DEBURR AS REQUIRED

SA 09/04/25

(40)

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SA 09/04/25

(40)

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

PTO. SA 09/04/27

(40)

5.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
 Identify and Stock
 Location: ST 139A

SA 09/04/28

(40)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3864-1 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: D Date: 09/04/27

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: <u>47351</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09.04.27	4	Diameter of $\phi 0.376$ " is not uniform- $\phi 0.394$ " on one end and $\phi 0.376$ " on other end	<u>PH</u> <u>QSI</u> <u>042</u> <u>09.04.27</u>	Ground handling lvs held in by AN6 bolt. Deviation due is non-structural ∴ ACCEPTABLE DEVIATION	<u>PH</u> <u>QSI</u> <u>042</u> <u>09/04/27</u>	<u>S</u> <u>09/04/27</u>	<u>PH</u> <u>QSI</u> <u>042</u> <u>09.04.27</u>	<u>S</u> <u>09/04/27</u>

NOTE: Date & initial all entries

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Drawing Name: BUSHING

Job Number: 47351

Part Number: D38641

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



09/04/08 JF

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-04-28

Dart Aerospace Ltd

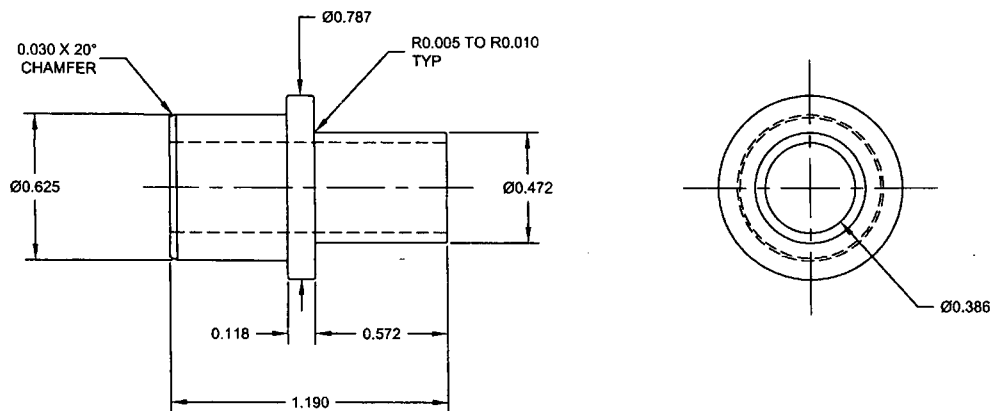
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3864-1 BUSHING

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 211551

NOTES:

- 1) MATERIAL: AISI 303 ROUND BAR
(DART SPEC M303RX.XXX)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.05 LBS

RELEASED
08.12.04

A NEW ISSUE		PH	08.12.04
REV.	DESCRIPTION		BY DATE
DESIGN	PH	DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN	PH		
CHECKED	PH	DRAWING NO.	REV. A
MFG. APPR.	PH	D3864	SHEET 1 OF 1
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	BUSHING	NTS
DATE	08.12.04	COPYRIGHT © 2004 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	